

Date: Wednesday, 13/08/2008 10:54:52 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 41199				Part Number	: D3303043		
Estimate Number	: 10420				Drawing Number	: D3303 REV. B		
P.O. Number	:				Project Number	: N/A		
This Issue	: 13/08/2008 S.O. No. :				Drawing Revision	: B		
Prsht Rev.	: NC				Material	:		
First Issue	: / / Type : SMALL /MED FAB				Due Date	: 27/08/2008 Qty: 30 Um: Each		
Previous Run	: 40906							
Written By	:							
Checked & Approved By	: JUL 08. 8.13							
Comment	: Est: A 04.09.07 New Issue KJ/JLM							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33031	Plate	 Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) PLATE Pick: Qty Part Number Description Batch 1 D3303-1 Plate B40942
2.0	D33033	Bracket	 Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) BRACKET Pick: Qty Part Number Description Batch 1 D3303-3 Bracket B38971
3.0	MS20426AD33	Rivet	 Comment: Qty.: 8.0000 Each(s)/Unit Total : 240.0000 Each(s) RIVET Pick: Qty Part Number Description Batch 8 MS20426AD3-3 Rivet M1503
4.0	MS20470AD44	Rivet, Universal Head	 Comment: Qty.: 16.0000 Each(s)/Unit Total : 480.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:54:52 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET ASSEMBLY
Job Number: 41199		Part Number: D3303043
Job Number:		
Seq. #:	Machine Or Operation:	Description :
	16 MS20470AD4-4 Rivet	4107823
5.0	MS21075L3	Nutplate
Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s) Nutplate Pick: Qty Part Number Description Batch		8/8/08/25 M108751 (12X) M108940 (08)
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg D3303 2- Identify as D3303-043		8/8/08/25 (30) 8/8/08/25 (x30) 8/8/08/25 (x30) 8/8/08/25 (x30)
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		8/8/08/25 (x30) 8/8/08/25 (x30) 8/8/08/25 (x30)
8.0	POWDER COATING	POWDER COATING M106442 8/8/08/26 (30)
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 ****MASK THREADS PRIOR TO PAINT**** START TIME: <u>9:10</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>9:40</u>		8/8/08/26 (x30) 8/8/08/26 (x30)
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 8/8/08/26 (x30) 8/8/08/26 (x30)
Comment: INSPECT POWDER COAT		8/8/08/26 (x30) 8/8/08/26 (x30)
10.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 188		8/8/08/26 (30) 8/8/08/26 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:54:52 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41199

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/27/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-0826

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

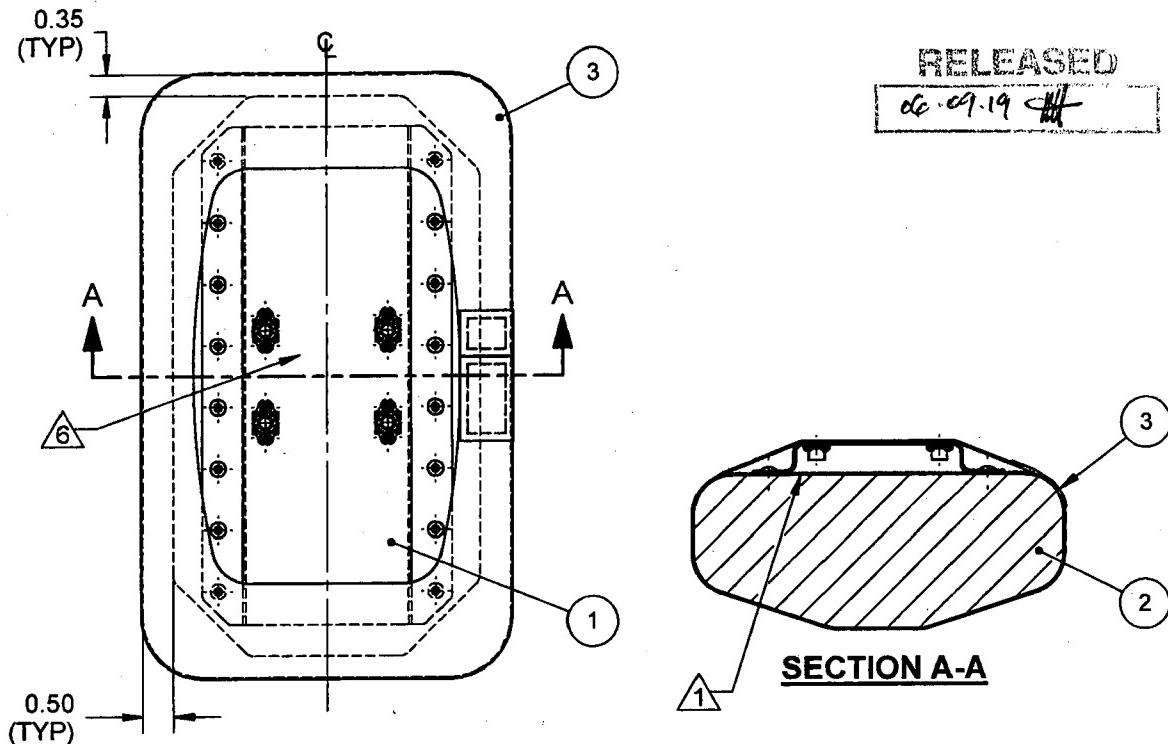
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3303
DATE 06.08.17	TITLE HEAD REST	REV. B SCALE 1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE
REV B	DATE 06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE



D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

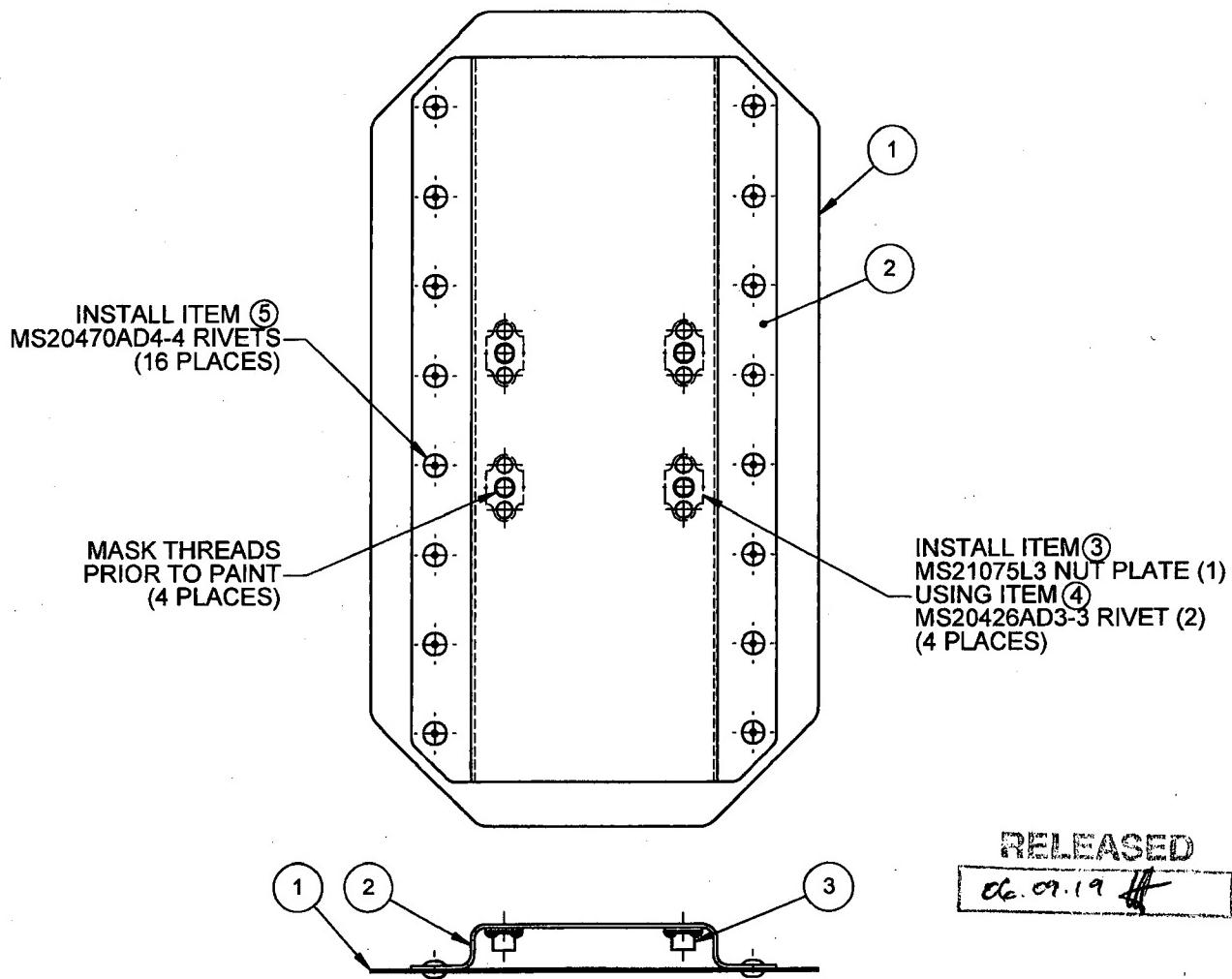
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 411991

COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>PH</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	



RELEASED

06.09.19 *CH***D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

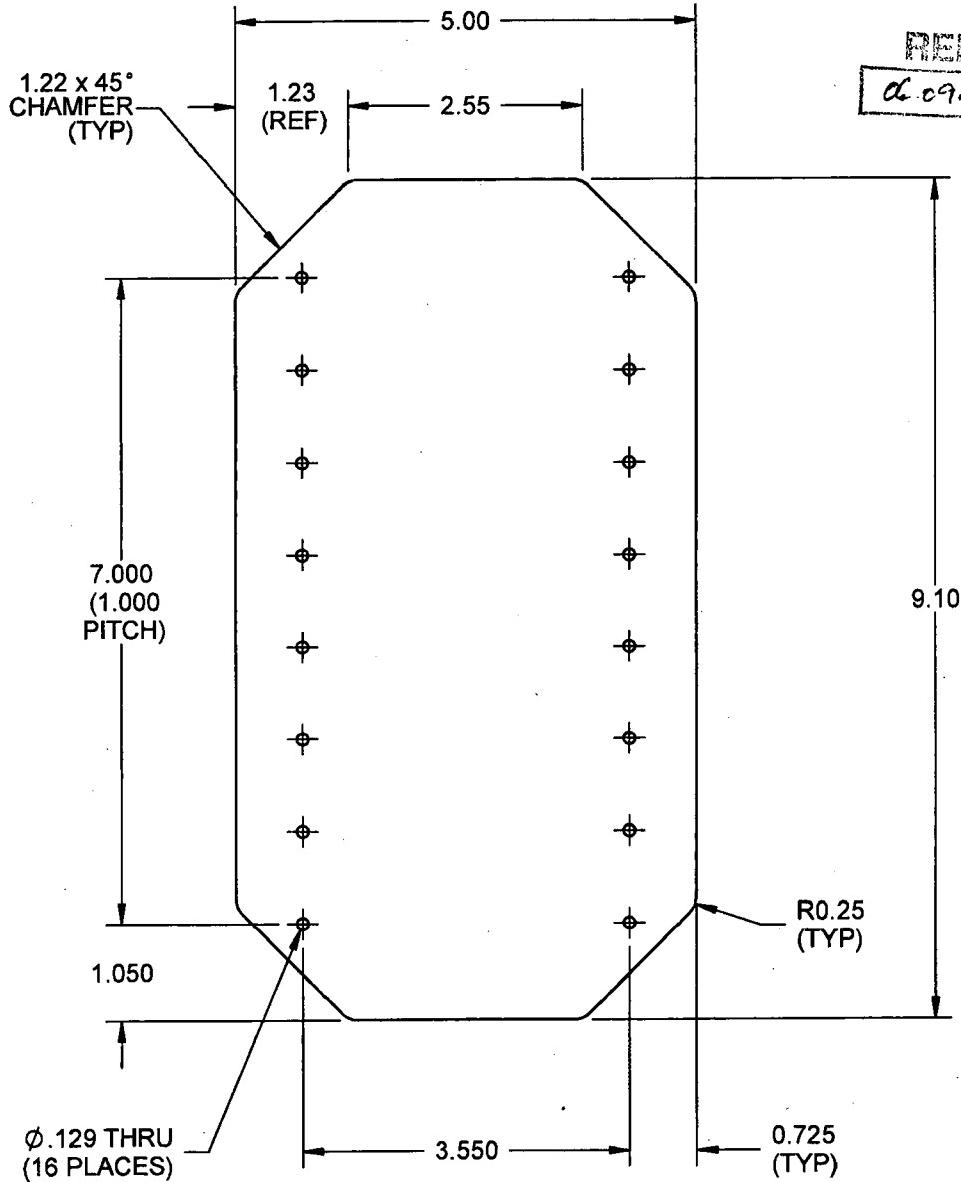
SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. *97199*

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

DART

DESIGN <i>RF</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JF</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	

**D3303-1 PLATE****NOTES:**

1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)

2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

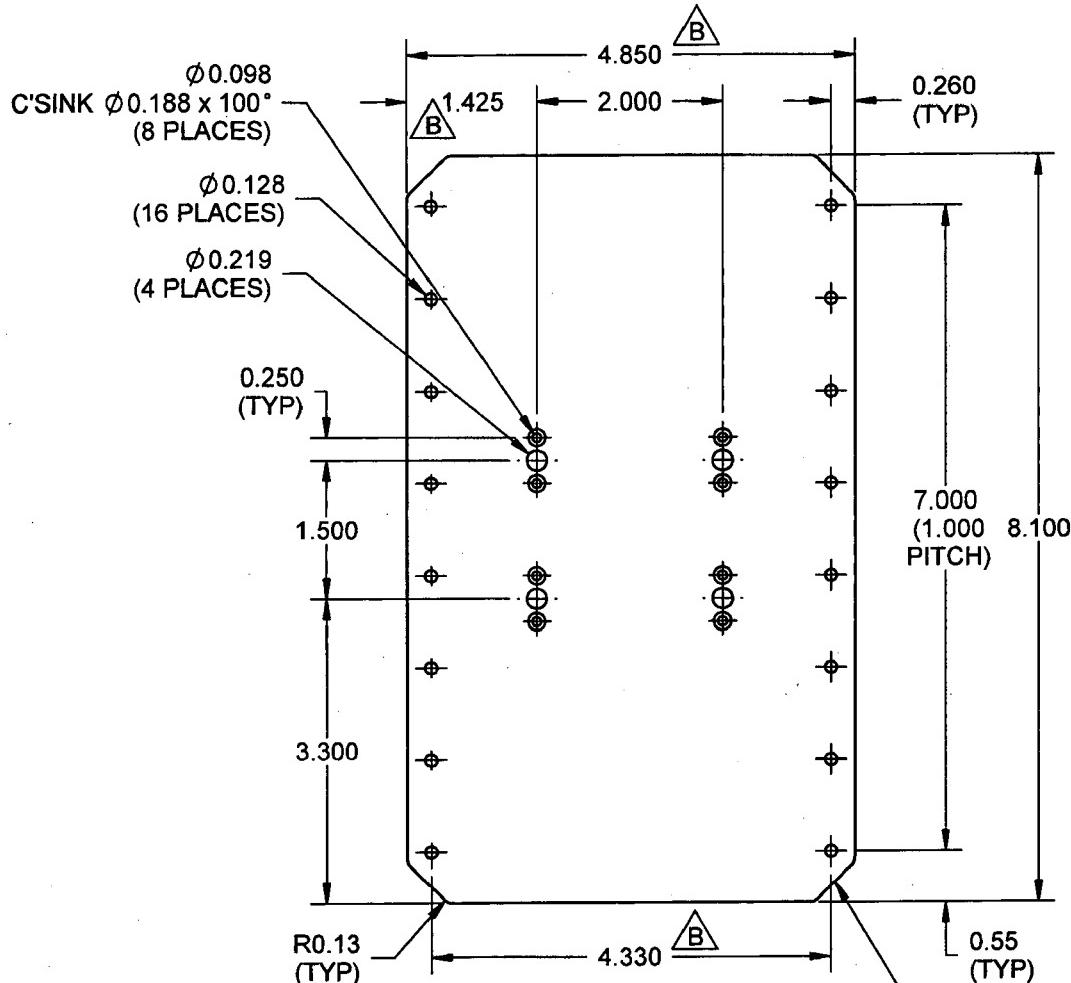
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDERNO. 971197**COPYRIGHT © 2004 BY DART AEROSPACE LTD**

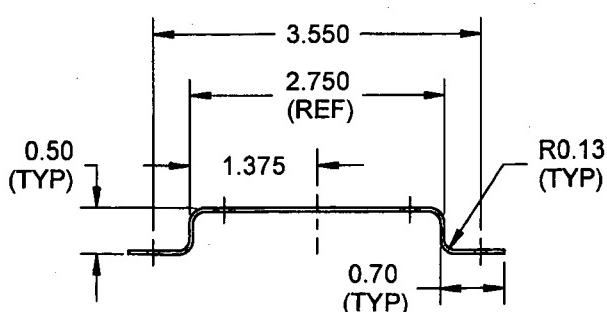
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>PF</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD	
CHECKED <i>PH</i>	APPROVED <i>HF</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 06.08.17		DRAWING NO. D3303	REV. B SHEET 4 OF 4 SCALE 1:2

**D3303-3F BRACKET FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
(TYP) UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41199

**D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.